

Date: Wednesday, 2/20/2008 4:20:29 PM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : MIRROR BRACKET
Job Number : 37520	
Estimate Number : 10144	
P.O. Number :	Part Number : D20136
This Issue : 2/20/2008 S.O. No. :	Drawing Number : D2013 REV C
Prsht Rev. : NC	Project Number : N/A
First Issue : / / Type : SMALL /MED FAB	Drawing Revision : C
Previous Run : 36919B	Material :
Written By :	Due Date : 3/20/2008 Qty: 4 Um: Each
Checked & Approved By : <u>AS 080221</u>	
Comment : Est Rev: A New Issue 05-11-01 JLM	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M304TR0750W049	304 RD Tube .750 x .049W
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Comment: Qty.: 1.8165 f(s)/Unit Total : 7.2660 f(s)
 Material: 3/4 O.D. x .049" wall, 304/316 SS Seamless Tubing
 (M304TR0.750W.049)
 Batch: M107518

SB 08/07/10 (4)

2.0	BRAKE NC	NC BRAKE
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Comment: NC BRAKE

- 1-Punch as per template D2013-T5 and Dwg D2013
- 2-Flatten ends of D2013-6 tube as per Dwg D2013 using DT8545
- 3-Bend tube as per Dwg D2013 using Jig DT8201 Identify as D2013-6.
- 4-Deburr as required

SB 08/04/14 (4)

FF 08-04-15

SB 08/09/14 (4)

3.0	QC5	INSPECT WORK TO CURRENT STEP
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Comment: INSPECT WORK TO CURRENT STEP

S 08/07/10 (4)

4.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1 SEE SECOND SHEET.

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: MIRROR BRACKET

Job Number: 37520

Part Number: D20136

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC21

FINAL INSPECTION/W/O RELEASE



08/09/14

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



4.0

ST 241

PC 8/2/11

(4)

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

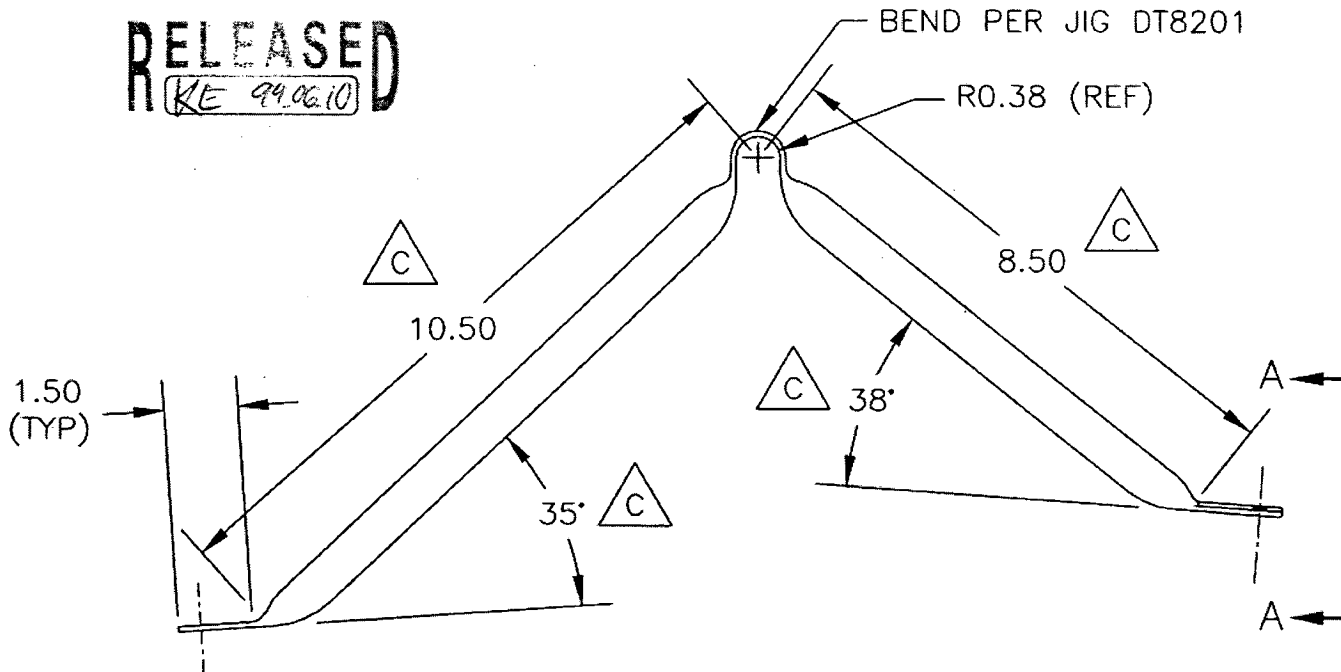
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

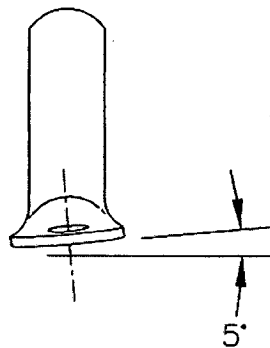
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

RELEASED
KE 99.06.10



D2013-1 LH SHOWN
D2013-2 RH OPPOSITE
(FOR 205 MIRROR)



VIEW A-A

DRILL $\phi 0.257$ (TYP)

0.400 (TYP)

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
375220

CUT LENGTH: 23.25 INCHES

MATERIAL: AISI 304/316 SS SEAMLESS TUBE,
0.750 OD x 0.049 WALL

DART



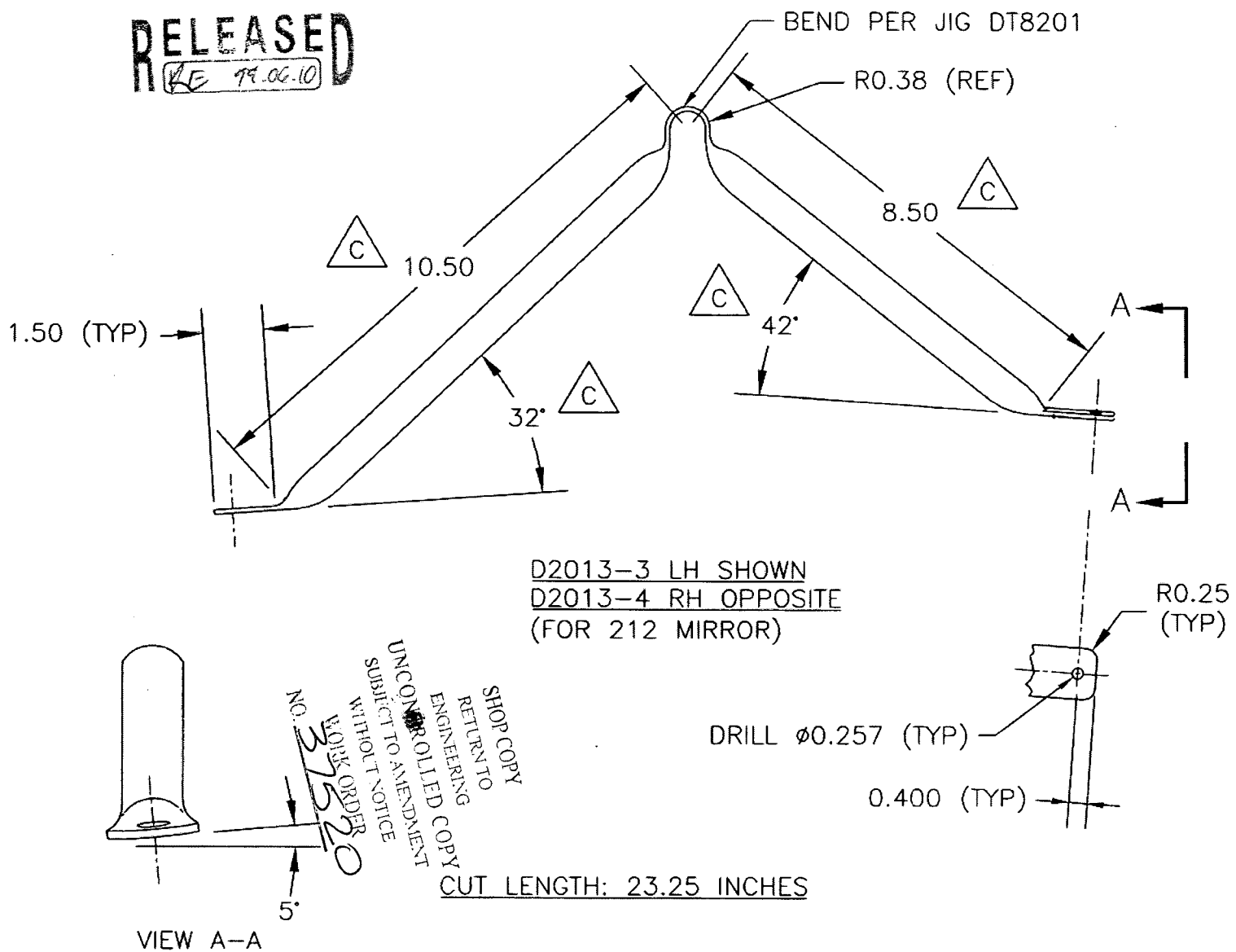
DESIGN	DRAWN BY	DART AEROSPACE LTD HAMKESBURY, ONTARIO, CANADA
JB	RF	
CHECKED KE	APPROVED RF	DRAWING NO. D2013
DATE 99.06.07		TITLE MIRROR BRACKET
A	90.10.22	NEW ISSUE
B	94.06.15	REDRAWN
C	99.06.07	REDRAWN, CHANGE OF DIMENSIONS
		REV. C
		SHEET 1 OF 3
		SCALE NTS

RELEASED
KE 79.06.10

DART

QA CONTROLLED

DESIGN	DRAWN BY	DART AEROSPACE LTD HAMMERSBURY, ONTARIO, CANADA
JB	RF	
CHECKED	APPROVED	DRAWING NO.
KE	[Signature]	D2013
DATE	TITLE	REV. C
99.06.07	MIRROR BRACKET	SHEET 2 OF 3
		SCALE N15



D2013-3 LH SHOWN
D2013-4 RH OPPOSITE
(FOR 212 MIRROR)

CUT LENGTH: 23.25 INCHES

MATERIAL: AISI 304/316 SS SEAMLESS TUBE,
0.750 O.D. x 0.049 WALL

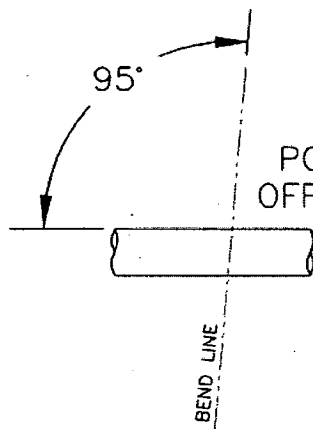
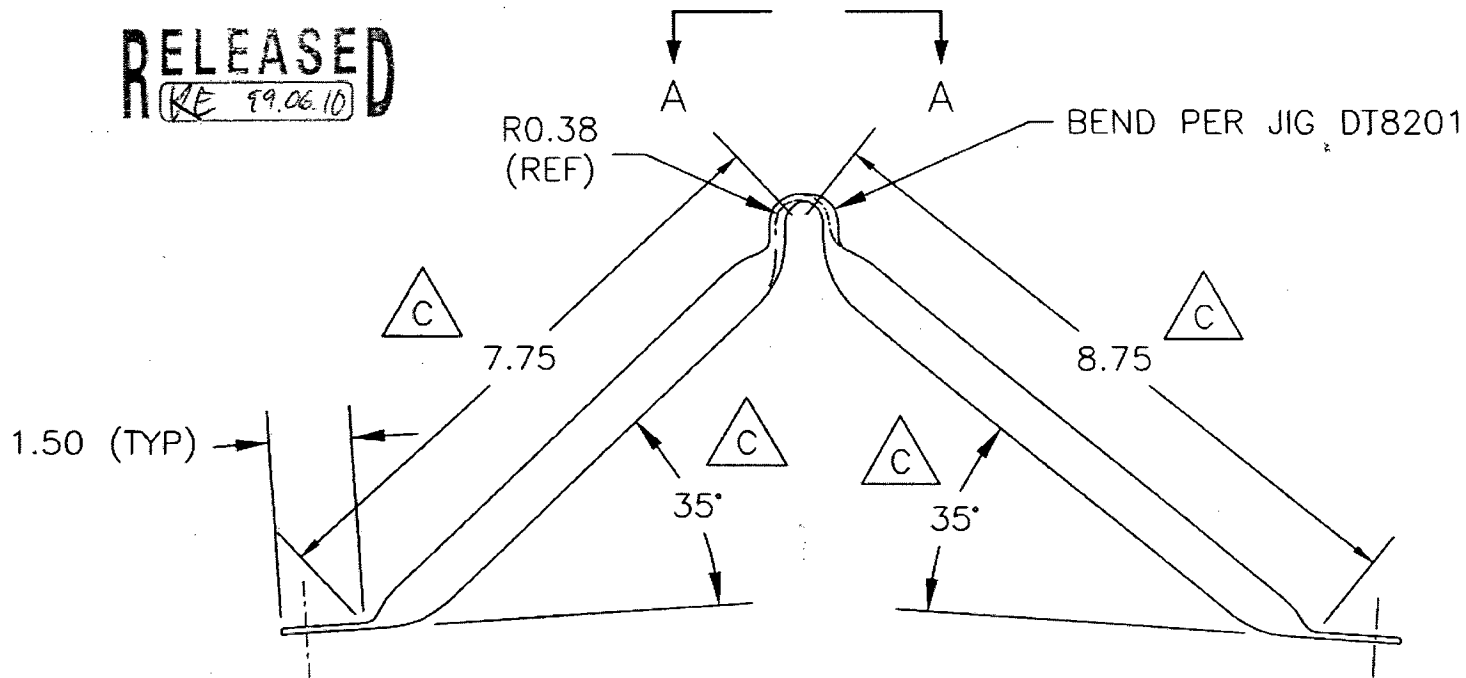
NO. 37520
WORK ORDER
SUBJECT TO AMENDMENT
UNCONTROLLED COPY
RETURN TO
ENGINEERING
SHOP COPY
RETURN TO

RELEASED
(KE 99.06.10)

DART



DESIGN	JB	DRAWN BY	RE	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED	KE	APPROVED	RE	DRAWING NO. D2013
DATE	99.06.07	TITLE	MIRROR BRACKET	REV. C SHEET 3 OF 3
		SCALE	NTS	



VIEW A-A

POSITION TUBE
OFFSET 5° IN JIG

NO. 37520
WORK ORDER
UNCONTROLLED COPY
SUBJECT TO AVALANCE
WITHOUT NOTICE
ENGINEERING
RETURN TO
SHOP COPY

D2013-5 LH SHOWN
D2013-6 RH OPPOSITE
(FOR 204 MIRROR)

DRILL $\varnothing 0.257$ (TYP)
R0.25 (TYP)
0.400 (TYP)

LENGTH: 20.75 INCHES

MATERIAL: AISI 304/316 SS SEAMLESS TUBE,
0.750 O.D. x 0.049 WALL